








# Work Order ID 72031

Monday, July 18, 2011 9:58:02 AM




Page 1

Item ID: D3443-043 Accept  Setup Start   
Revision ID: Stop   
Item Name: Strut Weldment Assembly  
Start Date: 7/18/2011 Start Qty: 4.00  Cust Item ID:  
Required Date: 7/25/2011 Req'd Qty: 4.00  Customer:  
Reference:


Approvals: Process Plan: P Date: 11-07-16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3443	Rev C

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld assembly as per dwg D3443								

EL 11-8-16 (X4)

110		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									

PC 11-08-17

120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

8/16/17

(X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72031

Monday, July 18, 2011 9:58:02 AM



Page 2

Item ID: D3443-043

Accept



Setup Start



Revision ID:

Item Name: Strut Weldment Assembly

Stop



Start Date: 7/18/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

0.00

Powder Coating

Memo

1-Mask holes as per dwg D3443 START TIME

OVEN TEMPERATURE: \_\_\_\_\_

FINISH

TIME: \_\_\_\_\_

9:30  
10:00

4X Ø M 11/08/19

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 d 11/08/19

150

Identify as per dwg & Stock Location

G.A

0.00



Packaging

Memo

w/o 71989 (2)

0.00

Packaging

w/o 71987 (2)

ES 11/08/22 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 72031**

Monday, July 18, 2011 9:58:02 AM



Page 3

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Revision ID:					Stop	
Item Name:	Strut Weldment Assembly					
Start Date:	7/18/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	7/25/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11-08-22  
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, July 18, 2011 9:58:09 AM

Page 1

Work Order ID: 72031

Parent Item: D3443-043

Parent Item Name: Strut Weldment Assembly

Start Date: 7/18/2011


Required Date: 7/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3443-3  Clevis		Manufactured	No			100	Each	3.0000	1	4			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

71895X1

Location

Loc Qty

Loc Code

WA022

3

69055

3

100

Each


4.0000

1

										4			

11-8-16

3

D3443-7  Tubing		Manufactured	No			100	Each	4.0000	1	4			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location

Loc Qty

Loc Code

WA

1

70595

1

WA023

3

69056

3

100

Each

32.0000


1

										4			

11-8-16

1

3

D3966-4-750  Pin, Dowel		Manufactured	No			100	Each	32.0000	1	4			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location

Loc Qty

Loc Code

ST100

32

58711

32

4

11-8-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

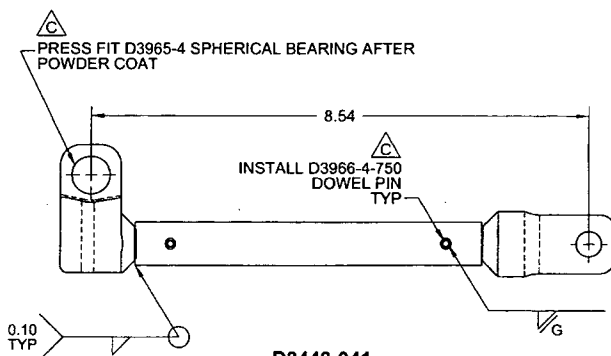
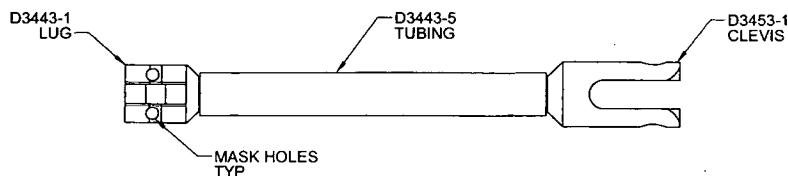
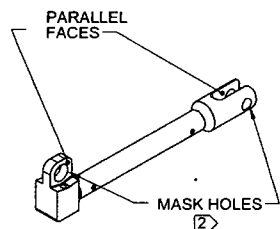
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1



**D3443-041**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72631

*2111-07-16*

**RELEASED**  
*09/06/25 MP*

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAU P/N (ZN C5-1, B5-2); D3966-4-750 WAS MCMASTER-CARR P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE, & Ø 0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3443	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STRUT WELDMENT ASSEMBLY	NTS
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

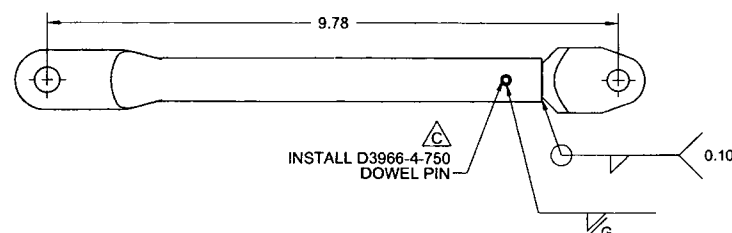
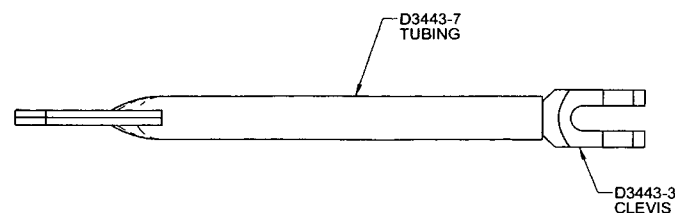
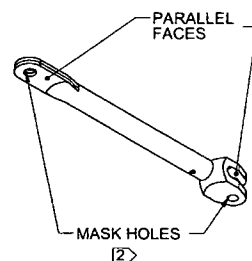
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**NOTE:** Date & initial all entries

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



**D3443-043**

72031

**RELEASED**  
09/08/25/14

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3443	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	STRUT WELDMENT ASSEMBLY	NTS
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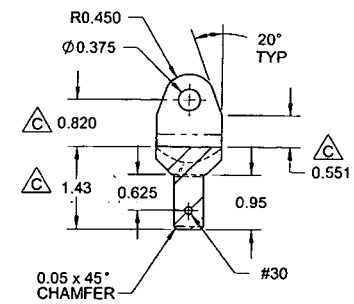
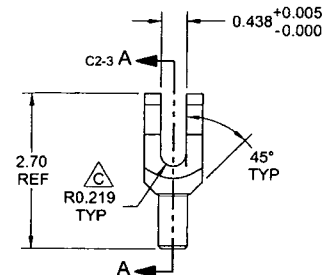
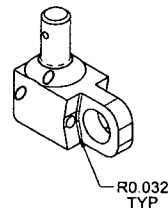
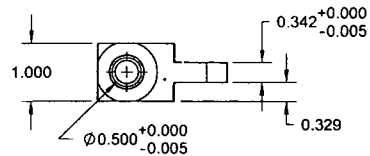
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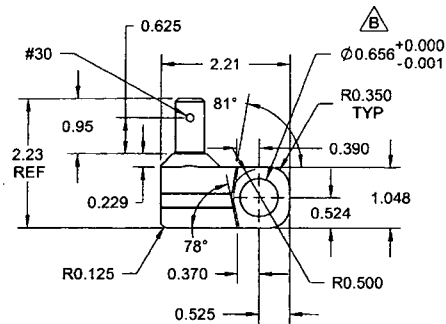
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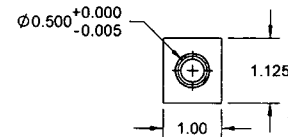
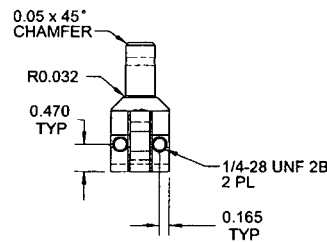
8 7 6 5 4 3 2 1



**SECTION A-A C4-3**



**D3443-1 LUG**





**D3443-3 CLEVIS**

**NOTES:**

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)  
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs  
D3443-3 = 0.35 lbs

7203

**RELEASED**  
09/08/25/16

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		<b>D3443</b>	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>STRUT WELDMENT ASSEMBLYNTS</b>	
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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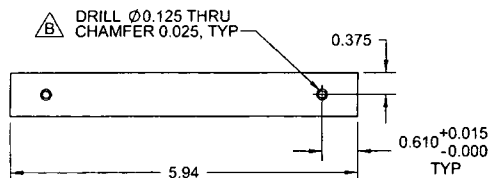
W/O:		WORK ORDER CHANGES					
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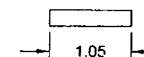
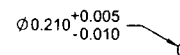
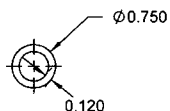
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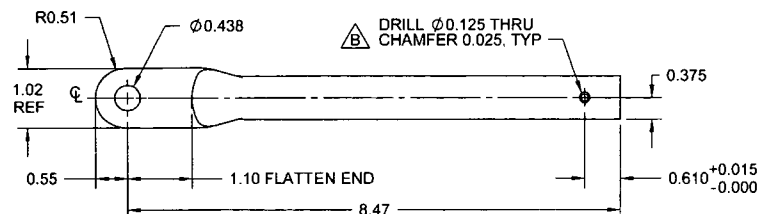
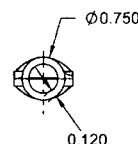
**D3443-5 TUBING**



**D3443-9 PIN**

**D3443-9 NOTES:**

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



**D3443-7 TUBING**

**D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs  
D3443-7 = 0.62 lbs

72631

**RELEASED**  
01/28/25 MD

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DT	DRAWING NO.	REV. C
MFG. APPR.	MD	<b>D3443</b>	SHEET 4 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	<b>STRUT WELDMENT ASSEMBLY NTS</b>	
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